

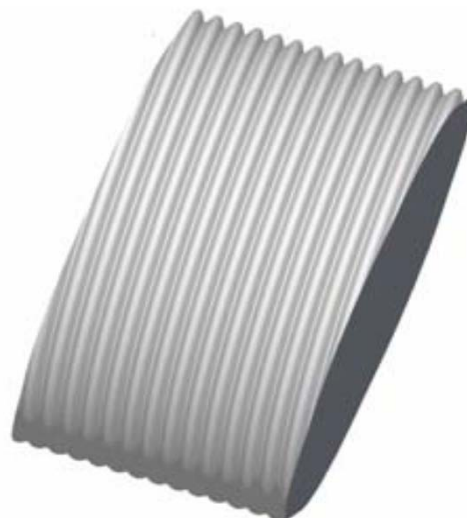
## Cylindrical Thread Rolling Die

A21-010

















HSS Cylindrical Thread Rolling  
Die production with conventional  
wheels.

Wheel No. 1 three profiles  
dressed on.

Wheel No. 2 single profile  
dressed on.



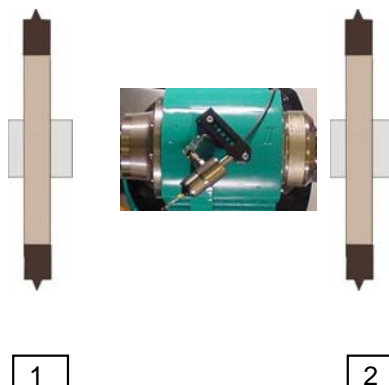
### 1. Cycletime for Production

Workpiece: Ø178 L76 Z310 P1.805 Helix 21° Material HSS								
Operations								
	Dress	MainThread	Dress	MainThread	Dress	MainThread	Dress	MainThread
Feed [mm/Min]	36	2000	36	2000	36	2000	36	2000
Increments [tot./part.]	0.1/0.01	0.4/0.1	0.2/0.01	0.2/0.01	0.1/0.01	0.03/0.01	0.05/0.01	0.03/0.005
Cutting speed [m/s]	12	45	12	45	12	45	12	45
Used wheels								
	1	1	1	1	2	2	2	2
Grinding time [s]	800	612	1600	1531	800	459	400	2755
Total cycle time	149 Min 17							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	DXF Ø200 C120
2	DXF Ø200 C220



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMAcfgr

Control: Fanuc 31i

Accessories: Dressing Unit

Responsible engineer: OP, 25.5.13

Coolant: Synthetic Oil, pressure 10 bar

Software: Quinto 5

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